

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 74.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015683**Date Inspected:** 12-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 815**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1800**Contractor:** Goodwin Steel, UK**Location:** Trentham, UK**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Cable Band**Summary of Items Observed:**

The following report is based on METS observations at Goodwin International, Trentham, UK on this date:

The QA Inspector observed welding of Casting GG29441-1, Drawing Number 5540-B10-2-F. The welding was being performed by Mr. M. Edwards. Mr. Edwards was using WPS04-0120F4G Issue 6. The welding was being performed at 26.6 volts and 200 amps. The heat input was and the travel speed were being monitored. The filler metal was AWS 5.20 E71T-1M. The shielding gas was Argon, 20% CO₂, 2% O₂. These are within the allowable range of the WPS. Welding was being performed in the 1G position. A localized preheat was used and the welder verified the preheat with a 1770 C temperature indicating crayon.

The inspector was presented the partial document package for the Cable Band East Panel Point 68 (EPP-68) consisting of castings 5540-B5-1-M-4, GG29424-4, and 5540-B5-1-F-6, GG29425-6. The document package is complete with the exception of the certificate of conformance for coating. This cable band is to be shipped to South Staffs for painting. A green tag will be assigned upon receipt of the shipper..

The inspector was presented the shipper for Cable Band West Panel Point 66 (WPP-66) consisting of castings 5540-B5-1-M-6, GG29424-6, and 5540-B5-1-F-4, GG29425-4. This cable band is to be shipped to South Staffs for painting. ABF-RFI-2141 is applicable to this cable band. The dimensional reports are not complete and the RFI is not referenced in the documentation. This package was returned for correction.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

SHOP REVIEW:

WPP-2, GG29436-8 and GG29437-8, a B9 Type 1 cable band was observed being machined at the Webster and Bennet machining center. The rough bore is being machined.

WPP-26, GG29436-5 and GG29437-6, a B9 Type 1 cable band was observed being machined at machining center BTD-3. It is at step 5: finish machine.

Casting GG29438-2, 5540-B10-1-M was observed at the layout table.



Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Riegler,Randy
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Quality Assurance Inspector

Reviewed By:	Edmondson,Fred
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QA Reviewer
